

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019790**Date Inspected:** 13-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Bao Qian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG Anchor Plate Assembly

PCMK: AP3031-001

Weld No: 417

Welder: 200113

Weld Repair No. WR18953

WPS-345-SMAW-3G(3F)-Repair

Component; OBG Anchor Plate Assembly

PCMK: AP3031-001

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Weld No: 437
Welder: 216086
Weld Repair No. WR18957
WPS-345-SMAW-3G(3F)-Repair

Component; OBG Anchor Plate Assembly
PCMK: AP3031-001
Weld No: 315
Welder: 054013
Weld Repair No. WR18945
WPS-345-SMAW-3G(3F)-Repair

Bay 28

This QA Inspector observed the following work in progress for Bay 28.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Yang Bai Qiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG Traffic Barriers
PCMK: E5-SB13067
Weld No: 026,031,057,062
Welder: 062265
WPS-B-P-2232-ESAB

Component; OBG Traffic Barriers
PCMK: E5-SB13062
Weld No: 001~012,032~043
Welder: 059466
WPS-B-P-2232-ESAB

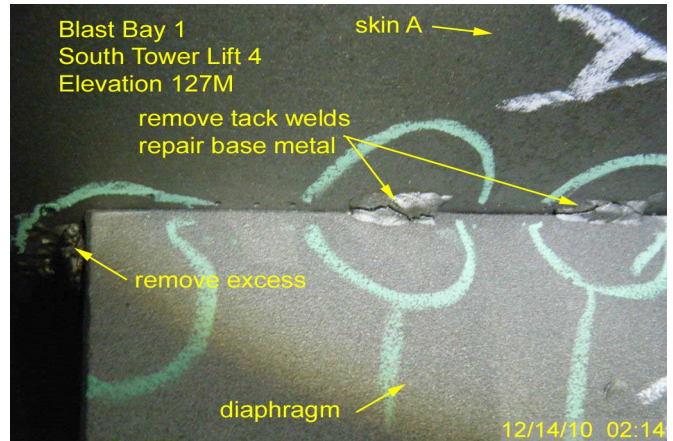
Blast Bay 1

This Caltrans QA Inspector and Mr. Bret Rice, and Mr. Mike Hasler performed a pre-blast visual inspection of the interior surface and internal components, Lift 4, SSDI tower subassembly, 116~131 meter mark to the bottom surface of the double diaphragm. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer